

Work Order ID 162769

Monday, June 12, 2017 12:42:44 PM

162769

Page 1

Item ID: D3947-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Panel , Upper RH Post (Sub-Component D350-766-015)
 Start Date: 6/19/2017 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 6/27/2017 Req'd Qty: 3.00 *3* Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan: (Signature) Date: JUN 12 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3947	A

110	THERMOFORMING MACHINE	0.00				3	JUN 28 2017	DAS 13 9-89
110								
Purchasing	Memo	0.00						
Purchasing	ISSUE P/O: 36858							
	SUPPLIER: PLASTECH							
	MANUFACTURE D3947-2 AS PER DWG							
	C OF C IS REQUIRED							

140	Receive & Inspect for Damage & Mat'l Certs	0.00						
140	HAND FINISHING THERMOFORMING							
Packaging	Memo	0.00						
Packaging								

*145.
SMALL FAB

TRIM TO DRAWING.

3x Sp 17-7-10
PTO →

DAS
C7
9-89
17/07/19

DQA: Aut Date: 2017-07-25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: JS Date: JUL 21 2017

Work Order update only ☐

Work Order: <u>162769</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3947-2</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>17-6553</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☒	

Date: 17/7/19 Step #: 110 QTY Effective: 3 MRB (QSI042) Approval
DAS
12
9-89 17/7/19

Description Work Order Deviation	Disposition	Completed By
Edge was trimmed 1.3" instead of 1.8".	Acceptable. Sufficient material for overlap and adjustment by customer.	<u>DAS</u> <u>12</u> <u>9-89</u> <u>17/7/19</u>
		Lead hand / Supervisor Approval Verification <u>DAS</u> <u>38</u> <u>9-89</u> <u>JUL 20 2017</u>
		QC / QA Coordinator Approval <u>DAS</u> <u>38</u> <u>9-89</u> <u>JUL 20 2017</u>

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☒ Doc/Data ☒ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☒ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
		Power Loss/Surge ☐ Folio/Program ☒ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☒ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Mistake ☐ Turning Sequence ☐

☒ OTHER: Supplier

Work Order ID 162769

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162769

Page 2

Item ID: D3947-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Panel , Upper RH Post (Sub-Component D350-766-015)
Start Date: 6/19/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 6/27/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00				<u>3</u>			DAS 38 9-89 JUL 20 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>51427</u> Memo	0.00 0.00				<u>3</u>			DAS 6 9-89 JUL 20 2017
180 *180* QC Quality Control	QC21 - Final Inspection - Work Order Release Memo	0.00 0.00							17/7/20 <u>df</u> DAS 21 9-89 JUL 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
QAO GE 98-C								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

Picklist Print

Monday, June 12, 2017 12:42:56 PM

Page 1

Work Order ID: 162769

162769

Parent Item: D3947-2

D3947-2

Parent Item Name: Panel , Upper RH Post (Sub-Component D350-766-015)

Start Date: 6/19/2017

Required Date: 6/27/2017

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL
NOW OUTSIDE PROCESS DD VERF:DP

IPP RevB
IPP REV:C 17.06.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3947-2P		Purchased	No				Each	0.0000					
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D3947-2P

Panel , Upper RH Post (Sub-Component D350-766-015)

**

3
3x SP 177-10

DQA: _____ Date: _____

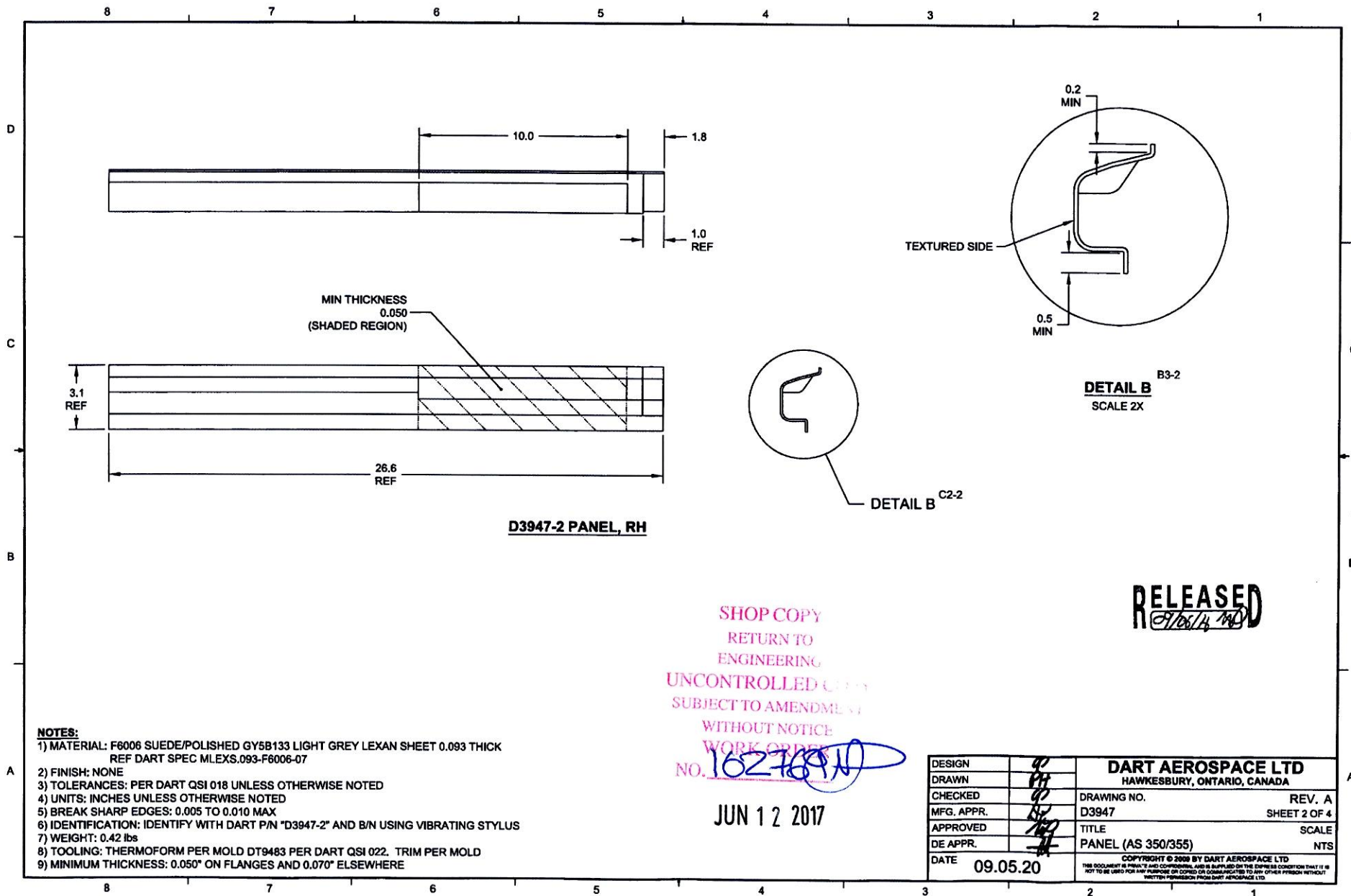


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36858**

Purchase Order Date 6/28/2017

PO Print Date 6/28/2017

Page Number 2 of 3

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 60
Currency CAD
FOB Destination-Collect

3	D3947-3P	Panel , Lower LH Post (Sub-Comp D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DWG D3947 REV. A
B162770

Line Total: \$255.00

4	D3947-2P	Panel , Upper RH Post (Sub-Component D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DWG D3947 REV. A
B162769

Line Total: \$255.00

5	D3947-1P	Panel , Upper LH Post (Sub-Comp D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DFWG D3947 REV. A
B162768

Note:

6/28/2017

Ship Date: 07/06/2017

Pick Ticket - 23194

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: CHANTEL LAVOIE
O

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: CHANTEL LAVOIE
O Email: clavole@dartaero.com
Tel: (613) 632-5200

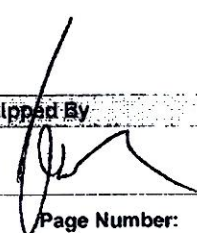
Purchase Order PO36858	Sales Order SO-019079	Incoterms	Payment Method COL
Carrier Account #	Ship Via FREIGHTCOM INC. -	Tracking Number	
Payment Terms NET 60	Account Status Active		

Item Number - Revision	Description	Quantity To Ship	UOM
---------------------------	-------------	---------------------	-----

CUSTOM -	SETS GREY POLYCARBONATE KIT Shipment Date: 7/6/2017 D3946 / D3947 SERIES HS Code: 8708.8.1000 - Country of Origin : CA	3 <u>3</u>	EA
	1 PC D3946-1P		
	1 PC D3947-4P		
	1 PC D3947-3P		
	1 PC D3947-2P ✓		
	1 PC D3947-1P		

8017-7-10

DAS
38
9-89

Number of Containers	Gross Weight	Shipped By
		

DART AEROSPACE LTD		Work Order: 162769
Description: Panel, Upper LH		Part Number: D3947-1
Inspection Dwg: D3947	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: **DAS** 07 9-89 Date: 17/07/18

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	Min	10.17"	✓			
0.2	Min	0.23"	✓			
0.5	Min	0.5"	✓			
1.8	Min	1.8"	✓			
3.1	REF	3.2"	✓			OK to use as is. See #140.
26.6	REF	26.675"	✓			
0.050	Min	0.067"	✓			
0.070	Min	0.075"	✓			

Measured by: **DAS** 07 9-89 Date: 17/07/18
Audited by: **DAS** 38 9-89 Date: JUL 20 2017
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	